



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5162-041

Job Sheet 180304



Part No: D5162-041

Job Qty: 1 ea

Part Name: Seat Structure Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/4/18

Job Tracking No:

Due Date: 7/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D3016 REV (DEO) A1, D5162 REV A, D5189 REV A, D3017 REV C IPP REV:A 14.11.05 NEW ISSUE
DD VERF:JLM IPP REV:B 15-02-06 AS PER DWG REV:A DD VERF:JLMIPP REV:C 16.08.31 ADD D3016
PARTS DD VERF:JLM

Ship Via:

004727

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	7/16/18	7/16/18	0.00	0.00	Start Up Large Fab-1		LZ
110	Large Fab	1 pcs	7/16/18	7/16/18	24.00	4.63	Large Fab 4		EL DAE
140	QC	1 pcs	7/16/18	7/16/18	0.00	0.00	QC5		38
165	Large Fab	1 pcs	7/16/18	7/16/18	0.00	4.63	Large Fab 4		38
170	QC	1 pcs	7/16/18	7/16/18	0.00	0.00	QC9		PD 15-07-26
175	QC	1 pcs	7/16/18	7/16/18	0.00	0.00	QC5		PD 15-07-26
180	HandFinish	1 pcs	7/16/18	7/16/18	0.00	0.47	HandFinish1		SA R-07-26
190	QC	1 pcs	7/16/18	7/16/18	0.00	0.00	QC7-5		38
200	Small Fab	1 pcs	7/16/18	7/16/18	0.00	1.00	Small Fab-8		38
210	QC	1 pcs	7/16/18	7/16/18	0.00	0.00	QC5		38
220	Powdercoat	1 pcs	7/16/18	7/16/18	0.00	0.29	Powdercoat3		38
230	QC	1 pcs	7/16/18	7/16/18	0.00	0.00	QC3		38
240	Small Fab	1 pcs	7/16/18	7/16/18	0.00	1.00	Small Fab-8		38
250	QC	1 pcs	7/16/18	7/16/18	0.00	0.00	QC5		38
260	Packaging	1 pcs	7/16/18	7/16/18	0.00	0.00	Packaging3-2		38
270	QC21-SA	1 Ea	7/16/18	7/16/18	0.00	0.00	QC21		38

M136370

START: 8:00

OV.T: 300" FINISH: 8:30

JUL 20 2018

53
8-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2199-31	Strut Details	1 Ea (1 ea)	90-Start up Operation	5020528
D3016-1	Tube	2 Ea (2 ea)	90-Start up Operation	5037289
D3016-11	Saddle	2 Ea (2 ea)	90-Start up Operation	5037785
D3016-3	Tube	4 Ea (4 ea)	90-Start up Operation	5037648
D3016-5	Tube	2 Ea (2 ea)	90-Start up Operation	5037783
D3016-7	Tube	4 Ea (4 ea)	90-Start up Operation	5057550
D3016-9	Saddle	2 Ea (2 ea)	90-Start up Operation	5037959
D5159-041	Seat Back Brace Assembly	1 Ea (1 ea)	90-Start up Operation	5086211
D5159-043	Seat Back Brace Assembly	1 Ea (1 ea)	90-Start up Operation	5086196
D5159-045	Seat Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5090915
M4130NT0.750W.049	4130 Round Tube .750 X.049W	13.8000 ft (13.8 ea)	90-Start up Operation	5060103
M4130NT0.750W.083	4130 Round Tube .750 X.083W	2.5000 ft (2.5 ea)	90-Start up Operation	5017143
D3016-13	Bracket	2 Ea (2 ea)	90-Start up Operation	509205

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																					
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D3016-15	Gusset	2 Ea (2 ea)	90-Start up Operation	5019171
D3016-17	Gusset	2 Ea (2 ea)	90-Start up Operation	5019185
D3017-11	Cap	4 Ea (4 ea)	90-Start up Operation	5019161
D3017-7	Lug	3 Ea (3 ea)	90-Start up Operation	5019245
D3020-1	Fitting	4 Ea (4 ea)	90-Start up Operation	5075006
D3022-1	Seat Pan	1 Ea (1 ea)	90-Start up Operation	5024798
D3023-1	Back Panel	1 Ea (1 ea)	90-Start up Operation	5064783
D4667-041	Armrest Stud Assembly	1 Ea (1 ea)	90-Start up Operation	5065443
D5190-1	Armrest Fitting	1 Ea (1 ea)	90-Start up Operation	5025169
D5190-3	Weld Pin	1 Ea (1 ea)	90-Start up Operation	4051112 F154143
MS20600-AD4W2	Rivet	46 Ea (46 ea)	200-Small Fab	5050041
AN3-12A	Bolt	3 Ea (3 ea)	240-Small Fab	5048376
AN4-14A	Bolt	2 Ea (2 ea)	240-Small Fab	5067888
AN4-4A	Bolt	1 Ea (1 ea)	240-Small Fab	5044215
AN4-6A	Bolt	1 Ea (1 ea)	240-Small Fab	5058982
AN970-4	Washer	1 Ea (1 ea)	240-Small Fab	5016395
D3024-1	Spacer	3 Ea (3 ea)	240-Small Fab	5093108
D3031-1	Loop	2 Ea (2 ea)	240-Small Fab	5089744
MS20600-AD4W4	Rivet	4 Ea (4 ea)	240-Small Fab	5048405
MS20600-AD4W5	Blind Rivet	8 Ea (8 ea)	240-Small Fab	5016897
MS21042L3	Nut	17 Ea (17 ea)	240-Small Fab	5089840
MS21042L4	Nut	8 Ea (8 ea)	240-Small Fab	5089365
MS24693-S272	Screw	4 Ea (4 ea)	240-Small Fab	5044219
MS27039-1-17	Screw (601.1954)	1 Ea (1 ea)	240-Small Fab	F1127831-4
MS27039-1-18	Screw	3 Ea (3 ea)	240-Small Fab	F124326
MS27039-1-19	Screw	4 Ea (4 ea)	240-Small Fab	5065263
MS27039-1-20	Screw	2 Ea (2 ea)	240-Small Fab	5000680
MS27039-4-20	Screw	4 Ea (4 ea)	240-Small Fab	5039035
MS27039-4-21	Screw	2 Ea (2 ea)	240-Small Fab	F1135774
NAS1149D0332J	Washer	30 Ea (30 ea)	240-Small Fab	5035396
NAS1149D0432J	Washer	17 Ea (17 ea)	240-Small Fab	F1157459-15
NAS43DD4-16FC	Spacer	2 Ea (2 ea)	240-Small Fab	5007039

MS20600-AD4W3

5016914

6x

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2199-31	1	6	0
	D3016-1	2	10	0
	D3016-11	2	10	0
	D3016-13	2	10	0
	D3016-15	2	8	0
	D3016-17	2	8	0
	D3016-3	4	20	0
	D3016-5	2	10	0
	D3016-7	4	20	0
	D3016-9	2	10	0
	D3017-11	4	24	0
	D3017-7	3	14	0
	D3020-1	4	20	0
	D3022-1	1	3	0
	D3023-1	1	2	0
	D4667-041	1	10	0
	D5159-041	1	0	0
	D5159-043	1	0	0
	D5159-045	1	0	0
	D5190-1	1	14	0
	D5190-3	1	4	0
	M4130NT0.750W.049	14	43	0
	M4130NT0.750W.083	3	23	0
200-Small Fab	MS20600-AD4W2	46	204	0
240-Small Fab	AN3-12A	3	34	0
	AN4-14A	2	262	0
	AN4-4A	1	46	0
	AN4-6A	1	1,202	0
	AN970-4	1	160	0
	D3024-1	3	3	0
	D3031-1	2	2	0
	MS20600-AD4W4	4	3,204	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

MS20600-AD4W5	8	156	0
MS21042L3	17	1,178	0
MS21042L4	8	1,425	0
MS24693-S272	4	109	0
MS27039-1-17	1	74	0
MS27039-1-18	3	1,262	0
MS27039-1-19	4	391	0
MS27039-1-20	2	29	0
MS27039-4-20	4	94	0
MS27039-4-21	2	25	0
NAS1149D0332J	30	1,549	0
NAS1149D0432J	17	190	0
NAS43DD4-16FC	2	21	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS					
	Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
	Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
	Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
	Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐			

Date: _____
DART AEROSPACE
Container No: S096418

Part: D5162 - 041
Job No: 180304
Serial No/Batch: S096418
 Revision: _____
 Inspector: _____
 Exp Date: _____
 Instructions: Various STC's

Stan #:
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL.: 1 813 832-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Date: 07/27/18

QTY Effective : _____

MRB (QSI042) Approval

	Disposition	
		Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

FAULT CATEGORY

☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong
☐ Set-up	☐ Folio/Program	☐ Outside Dimensions
☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect
☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing
☐ Contamination	☐ Out of Sequence	☐ Part Moved
☐ Countersink	☐ Off-set	☐ Drawing
☐ Cut Too Short	☐ Misabeled	☐ Finish
☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread
☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence